

Work Order ID 68713

Wednesday, April 20, 2011 9:56:07 AM



Page 1

Item ID: D3912-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Eyebolt Receiver Assembly

Start Date: 4/20/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/21/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3912	B								
100	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									
110		0.00							
Small Fab	Memo	0.00							
Small Fab	1-Assemble D3912-1/-3/-5 and install rivets as per dwg TRIM RIVETS 1.250" LONG								
	2- Install helical, spring plunger and spring pin lanyard assy as per dwg								
120	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

EJB/04/20 (2)

EJB/04/20 (2)

S. L. L. 20

(40)

Work Order ID 68713

Wednesday, April 20, 2011 9:56:07 AM



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Item ID: D3912-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Eyebolt Receiver Assembly

Start Date: 4/20/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/21/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

PPP67919

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

ME

11-04-20

Picklist Print

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Page 1

Work Order ID: 68713

Parent Item: D3912-041

Parent Item Name: Eyebolt Receiver Assembly



Start Date: 4/20/2011

Required Date: 4/21/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: new issue DD 09.11.18 verified by:EC IPP Rev:B
10.06.10 memo in seq110 ***IF PLUNGER GOES IN TO DEEP, INSTALL A
WASHER (AN960C516L) IF NECESSARY BETWEEN PLUNGER AND
D3912-1. YOU MAY HAVE TO ENLARGE WASHER HOLE FOR IT TO
FIT*** DD verf:JLM IPP REV:C AS PER REV B 10-08-05 JLM
VERIFIED:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
NAS1149C0663R Washer		Purchased	No				Each	253.0000	1				
<div> <div>Location</div> <div>ST297</div> <div>110139</div> <div>116893</div> </div> <div> <div>Loc Qty</div> <div>253</div> <div>53</div> <div>200</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													
D3912-1 Eyebolt		Manufactured	No			100	Each	15.0000	1				
<div> <div>Location</div> <div>ST091</div> <div>65095</div> <div>68380</div> </div> <div> <div>Loc Qty</div> <div>15</div> <div>3</div> <div>12</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													
* D3912-3 Eyebolt Block		Manufactured	No			100	Each	1.0000	2				
<div> <div>Location</div> <div>ST091</div> <div>66320</div> </div> <div> <div>Loc Qty</div> <div>1</div> <div>1</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													

B68378 (2x)

Picklist Print

Wednesday, April 20, 2011 9:56:05 AM

Page 2

Work Order ID: 68713

Parent Item: D3912-041


Parent Item Name: Eyebolt Receiver Assembly


Start Date: 4/20/2011

Required Date: 4/21/2011


Start Qty: 1.00


Required Qty: 1.00

D3912-5 Manufactured No 100 Each 7.0000

 Eyebolt Plate


2 2

 4/20/2011


Location	Loc Qty	Loc Code
ST091	7	
66160	7	

D3801-1 Manufactured No 15.0000

 Hand Retractable Spring Plunger


1

 4/20/2011


Location	Loc Qty	Loc Code
ST084	15	
65630	3	
68379	12	

MS20615-4M20 Purchased No 100 Each 252.0000

 RIVET

8 8

 4/20/2011

Location	Loc Qty	Loc Code
GA	252	
117071	252	

MS21209-F615 Purchased No 58.0000

 Heli-Coil

1

 4/20/2011

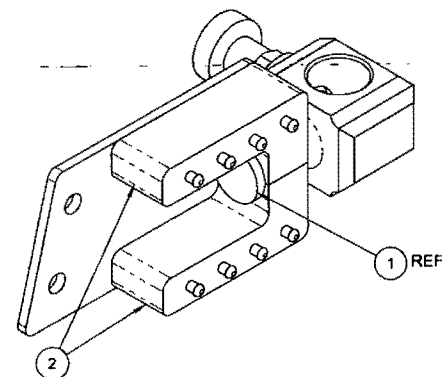
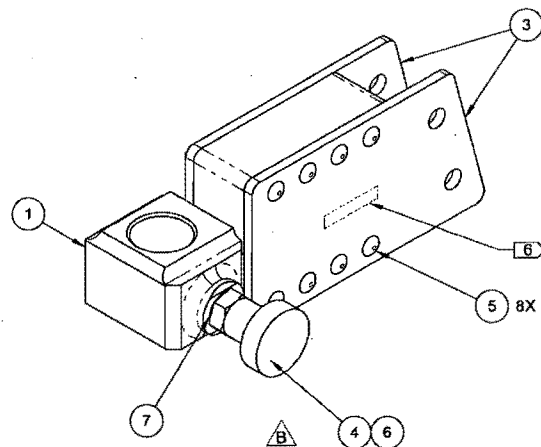
Location	Loc Qty	Loc Code
ST305	58	
108170	37	
108244	21	

Wednesday, April 20, 2011 9:56:05 AM

Shop Packet Print

Page 2

ITEM	QTY	P/N	DESCRIPTION
	X	D3912-041	EYEBOLT RECEIVER ASSY
1	1	D3912-1	EYEBOLT
2	2	D3912-3	EYEBOLT BLOCK
3	2	D3912-5	EYEBOLT PLATE
4	1	D3801-1	SPRING PLUNGER
5	8	MS20815-4M20	RIVET
6	1	MS21209-F615	HELICAL
7	1	NAS1149F0332P	WASHER



SUPPLEMENTAL ISO VIEW
(EYEBOLT PLATE REMOVED
TO SHOW INTERIOR FEATURES)

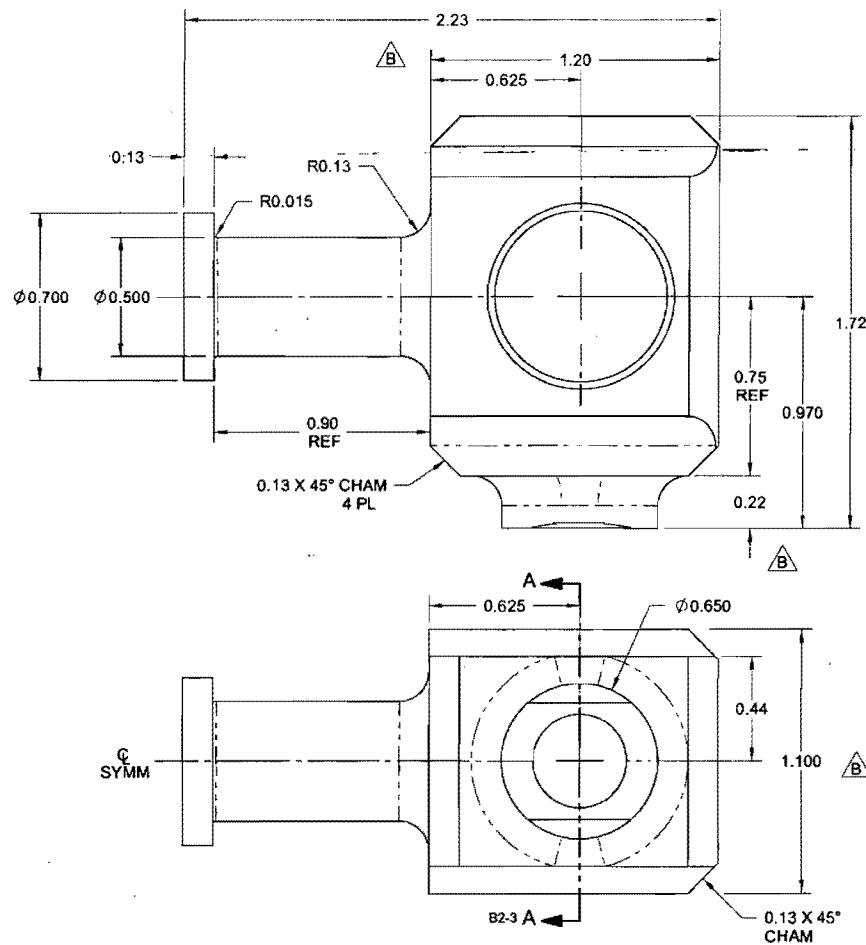
D3912-041 EYEBOLT RECEIVER ASSY

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3912-041 USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT -041: 1.58 lbs

B	D3801-1 WAS D3810-1 SPRING PLUNGER; D4028-041 RMV; MS21209-F615 WAS MS21209-C610 HELICAL; (1) WASHER NAS1149C0683R ADDED; BOSS ADDED TO D3912-1.	JPH	10.06.28
A	NEW ISSUE	JPH	10.03.04
REV	DESCRIPTION	BY	DATE
DESIGN	1/5		
DRAWN	1/1		
CHECKED	1/1		
MFG. APPR.	1/1		
APPROVED	1/1		
DE APPR.	1/1		
DATE	10.06.28		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. B
DRAWING NO. D3912	SHEET 1 OF 3
TITLE EYEBOLT RECEIVER ASSY	SCALE NTS

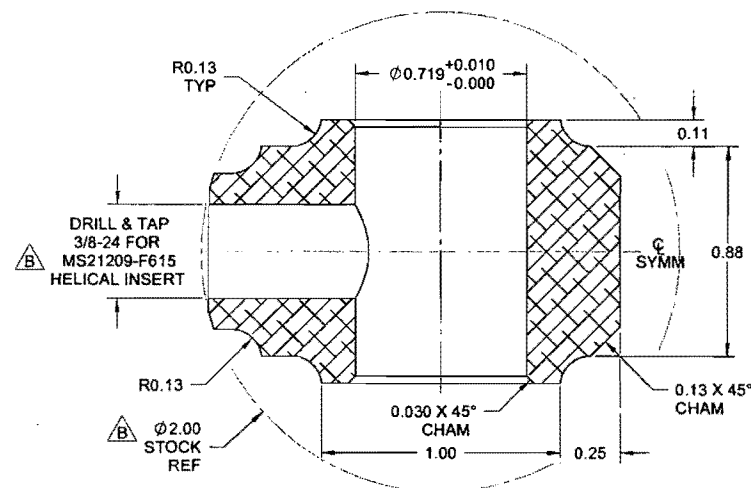
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D3912-1 EYEBOLT

NOTES:

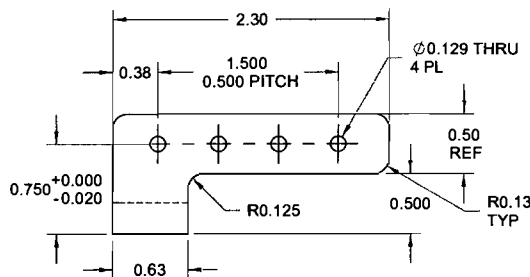
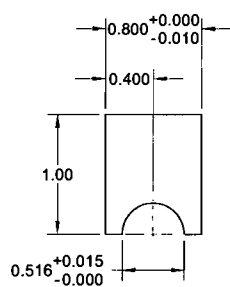
- 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582
REF DART SPEC M303R OR M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ID AT ASSEMBLY
- 7) WEIGHT: 0.45 lbs



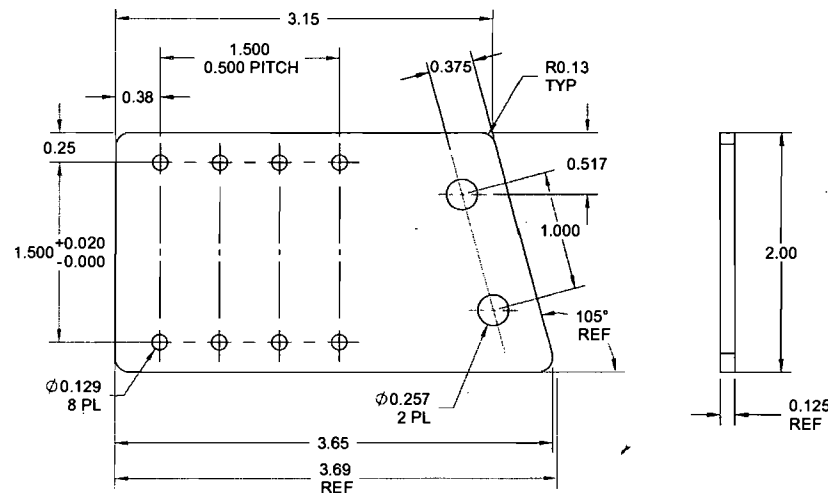
SECTION A-A B6-3

RELEASED
2010-07-16

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	8	DRAWING NO.	REV. B
CHECKED	8	D3912	SHEET 2 OF 3
MFG. APPR.	8	TITLE	SCALE
APPROVED	8	EYEBOLT RECEIVER ASSY	NTS
DE APPR.	8	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DATE	10.06.28		



D3912-3 EYEBOLT BLOCK



D3912-5 EYEBOLT PLATE

NOTES:

1) MATERIAL -3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M303B OR M304B

-5: 303/304/316 STAINLESS STEEL SHEET ANNEALED-2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME 5A240
REF DART SPEC M303S11GA OR M304S11GA

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: ID AT ASSEMBLY

7) WEIGHT -3: 0.30 lbs

-5: 0.24 lbs

18713

RELEASED
2010-07-16
JMD

DESIGN	ASS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SL	DRAWING NO.	REV. B
CHECKED	SL	D3912	SHEET 3 OF 3
MFG. APPR.	SL	TITLE	SCALE
APPROVED	SL	EYEBOLT RECEIVER ASSY	NTS
DE APPR.	SL	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.06.28		

